

**WHAT IS CLAIMED IS:**

- 1 *pub CIS* 1. A pressing apparatus for producing from a paperboard blank a food  
2 service paperboard container having an overturned rim provided with folds,  
3 comprising:  
4 a first die that includes a first base and a first platform movable with respect  
5 to the first base, said first base having a curved surface for engaging an outer  
6 periphery of a paperboard blank;  
7 a second die positioned in opposing relation to the first die and including a  
8 second base and a second platform movable with respect to the second base, said  
9 second die being movable with respect to the first die, said second base having a  
10 curved surface for mating with the curved surface on the first die and engaging the  
11 outer periphery of the paperboard blank so that the outer periphery of the  
12 paperboard blank is pressed between the curved surface of the first base and the  
13 curved surface of the second base;  
14 a first cast-in heater mounted within a recess in the first die, the first cast-in  
15 heater including a resistor wire embedded within a thermally conductive cast-in  
16 material; and  
17 a second cast-in heater mounted within a recess in the second die, the second  
18 cast-in heater including a resistor wire embedded within a thermally conductive  
19 cast-in material.

1 *Sub 4* 2. The pressing apparatus according to Claim 1, wherein the recess in  
which the first cast-in heater is mounted is in the first base.

1 3. The pressing apparatus according to Claim 2, wherein the recess in  
2 which the second cast-in heater is mounted is in the second base.

1 4. The pressing apparatus according to Claim 1, wherein the cast-in  
2 material of the first and second cast-in heaters is a thermally conductive material.

1 5. The pressing apparatus according to Claim 4, wherein the cast-in  
2 material of the first and second cast-in heaters is a ferrous or non-ferrous based  
3 alloy including an iron-based alloy, an aluminum-based alloy, a copper-based  
4 alloy, a magnesium-based alloy, a nickel-based alloy or a titanium-based alloy.

1 6. The pressing apparatus according to Claim 1, wherein the resistor wire  
2 of the first and second cast-in heaters is a coiled resistor wire located within a  
3 sleeve.

1 7. The pressing apparatus according to Claim 1, wherein only a single  
2 cast-in heater is mounted in the first die and only a single cast-in heater is  
3 mounted in the second die.

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1 8. A pressing apparatus for producing a food service paperboard  
2 container from a paperboard blank, wherein the paperboard container has an  
3 overturned rim provided with folds, comprising:  
4 a first die having a curved pressing surface;  
5 a second die positioned in opposing relation to the first die and having a  
6 curved pressing surface, at least one of said first and second dies being movable  
7 relative to the other of the first and second dies to cause an outer periphery of a  
8 paperboard blank to be pressed between the curved pressing surface of the first die  
9 and the curved pressing surface of the second die; and  
10 a cast-in heater mounted in either the first die or the second die.

1 9. The pressing apparatus according to Claim 8, wherein the cast-in  
2 heater is mounted in a recess in the first die.

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1 10. The pressing apparatus according to Claim 9, wherein the first cast-in  
2 heater is mounted in the first die and including a second cast-in heater mounted in  
3 the second die.

1 *Sub C1* 11. The pressing apparatus according to Claim 8, wherein the cast-in  
2 heater includes a resistor wire embedded within a thermally conductive cast-in  
3 material.

1 12. The pressing apparatus according to Claim 11, wherein the cast-in  
2 material is a ferrous or non-ferrous based alloy including an iron-based alloy, an  
3 aluminum-based alloy, a copper-based alloy, a magnesium-based alloy, a nickel-  
4 based alloy or a titanium-based alloy.

1 13. The pressing apparatus according to Claim 11, wherein the resistor  
2 wire is a coiled resistor wire located within a sleeve.

1 14. The pressing apparatus according to Claim 8, wherein a single cast-in  
2 heater is mounted in the first die and a single cast-in heater is mounted in the  
3 second die.

1 15. The pressing apparatus according to Claim 8, wherein the first die  
2 includes a first base and a first platform movable with respect to the first base,  
3 said curved surface being provided on said first base.

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16. The pressing apparatus according to Claim 8, wherein the second die  
includes a second base and a second platform movable with respect to the second  
base, said curved surface being provided on said second base.

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